

Date: Tuesday, 06/01/2009 10:29:26 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TURNING DETAIL FOR D2891-1
 Job Number : 44410
 Estimate Number : 13232
 P.O. Number :
 This Issue : 06/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : DSK076
 Drawing Number : DSK076 REV.A
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 43868 Material :
 Due Date : 16/01/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : Julie Dawson
 Comment : est rev A. 08.03.13 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6104003 Round Billet, 17-4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch: B43919

Ref 09/01/07

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: DOOSAN LATHE

Turn blank for as per Folio FA046

Ref 09/01/07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ref 09/01/07 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11 (8)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

Ref 09/01/07 (8)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/12 (8)

Job Completion



MF 09-01-12

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------------|--------|---------------------------|
| DART AEROSPACE LTD | | Work Order: <u>144/10</u> |
| Description: Turning Detail for D2891-1 | | Part Number: DSK076 |
| Inspection Dwg: DSK076 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 2.274 | 2.279 | | 2.279 | 2.279 | 2.279 | 2.279 | 2.279 |
| B | 3.702 | 3.722 | | 3.702 | 3.703 | 3.703 | 3.712 | |
| C | 2.564 | 2.584 | | 2.574 | 2.574 | 2.574 | 2.574 | |
| D | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | |
| E | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | |
| F | 2.464 | 2.484 | | 2.474 | 2.474 | 2.474 | 2.474 | |
| G | 2.029 | 2.049 | | 2.039 | 2.039 | 2.039 | 2.039 | |
| H | 2.964 | 2.984 | | 2.974 | 2.974 | 2.974 | 2.974 | |
| I | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | |
| K | 0.090 | 0.110 | | | | | | |
| L | | | | | | | | |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | |
|-------------------------|-----------------------|
| Measured by: <u>RP</u> | Date: <u>09/01/07</u> |
| Audited by: <u>J.F.</u> | Date: <u>09/01/11</u> |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM | <u>[Signature]</u> |

| | | |
|------------------------------------------------|---------------|-----------------------------------|
| DART AEROSPACE LTD | | Work Order: <u>44410</u> |
| Description: Turning Detail for D2891-1 | | Part Number: DSK076 |
| Inspection Dwg: DSK076 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article** ☐ **Prototype**

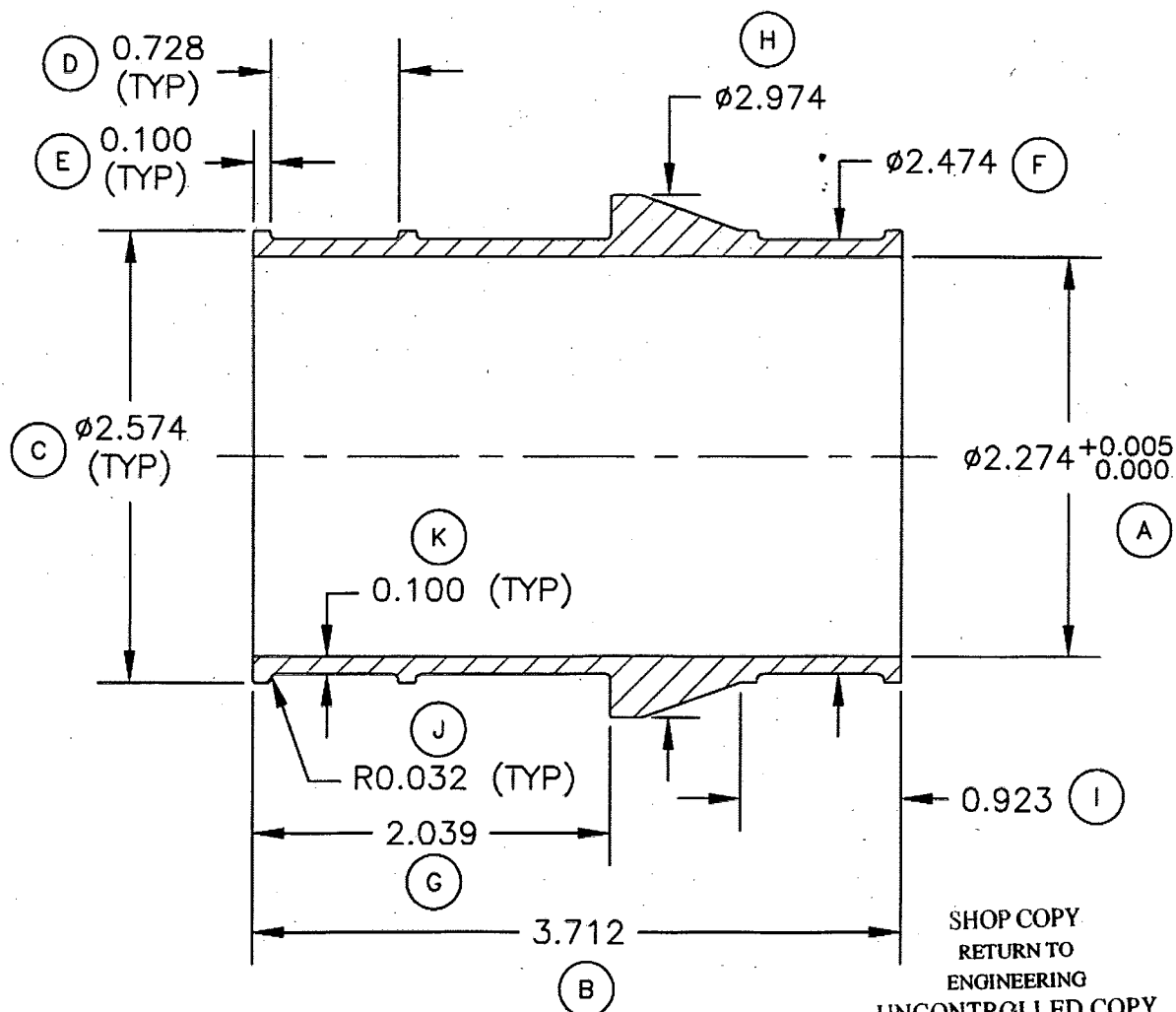
| | | | | Record Actual Dimensions | | | | |
|----------------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 2.274 | 2.279 | | 2.279 | 2.279 | 2.279 | 2.279 | 2.279 |
| B | 3.702 | 3.722 | | 3.702 | 3.703 | 3.703 | 3.712 | |
| C | 2.564 | 2.584 | | 2.574 | 2.574 | 2.574 | 2.574 | |
| D | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | |
| E | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | |
| F | 2.464 | 2.484 | | 2.474 | 2.474 | 2.474 | 2.474 | |
| G | 2.029 | 2.049 | | 2.039 | 2.039 | 2.039 | 2.039 | |
| H | 2.964 | 2.984 | | 2.974 | 2.974 | 2.974 | 2.974 | |
| I | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | |
| K | 0.090 | 0.110 | | | | | | |
| L | | | | | | | | |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | |
|--------------------------------|------------------------------|
| Measured by: <u>RP</u> | Date: <u>09/01/07</u> |
| Audited by: <u>J.F.</u> | Date: <u>09/01/11</u> |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM | <u>[Signature]</u> |

DART

| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CH | APPROVED CH | DRAWING NO. DSK 076 | REV. A SHEET 1 OF 1 |
| DATE 03.05.20 | | TITLE TURNING DETAIL FOR D2891-1 | SCALE 1:1 |
| A | 03.05.20 | NEW ISSUE | |

RELEASED
03.07.01 CH**D2891-1 TURNING DETAIL**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 442970

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.